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RBT18560
Job Sheet 189441



Part No: RBT18560

Job Qty: 10 pcs *31*

Part Name: Engine Gearbox Seal Puller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/24/19

Job Tracking No:

Due Date: 2/28/19 *March 5*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18560 Rev 4 IPP Rev A 17.11.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	10 pcs	2/28/19		0.00	10.00	Small Fab - 1		DAS 58 FEB 07 2019 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	10 pcs	2/28/19		0.00	0.00	QC 5 - 10		DAS 30 28 9-89 19/02/08
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	10 pcs	2/28/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	10 pcs	2/28/19	0.00 0.00	QC 21 - FG - 21	FEB 08 2019
					QC 21 - FG - 70	

Part Op 110 - (Small Fab) - Assemble as per DWG. Sheet 1
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

DAS
21
9-85

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3408A94	Ball Plunger without thread locker	20 Ea (2 ea)	110-Small Fab - 1	5031251
90565A330	Tall Nut 1/2-20 UNF	10 Ea (1 ea)	110-Small Fab - 1	5032757
91255A542	Button Head Socket Cap Screw 5/16-20 UNC x 1	20 Ea (2 ea)	110-Small Fab - 1	5031238
94846A525	Jam Nut 1/2-20	10 Ea (1 ea)	110-Small Fab - 1	5031248
NTA-815	Thrust Bearing	10 Ea (1 ea)	110-Small Fab - 1	5033969
RBT18560-1	Puller	10 pcs (1 ea)	110-Small Fab - 1	5036963
RBT18560-11	Upright	20 pcs (2 ea)	110-Small Fab - 1	5137722x5
RBT18560-3	Ring	10 pcs (1 ea)	110-Small Fab - 1	5037206
RBT18560-5	Screw	10 pcs (1 ea)	110-Small Fab - 1	5148382
RBT18560-9	Cross Bar	10 pcs (1 ea)	110-Small Fab - 1	5131180
TRA-815	Bearing Washer	20 Ea (2 ea)	110-Small Fab - 1	5038794

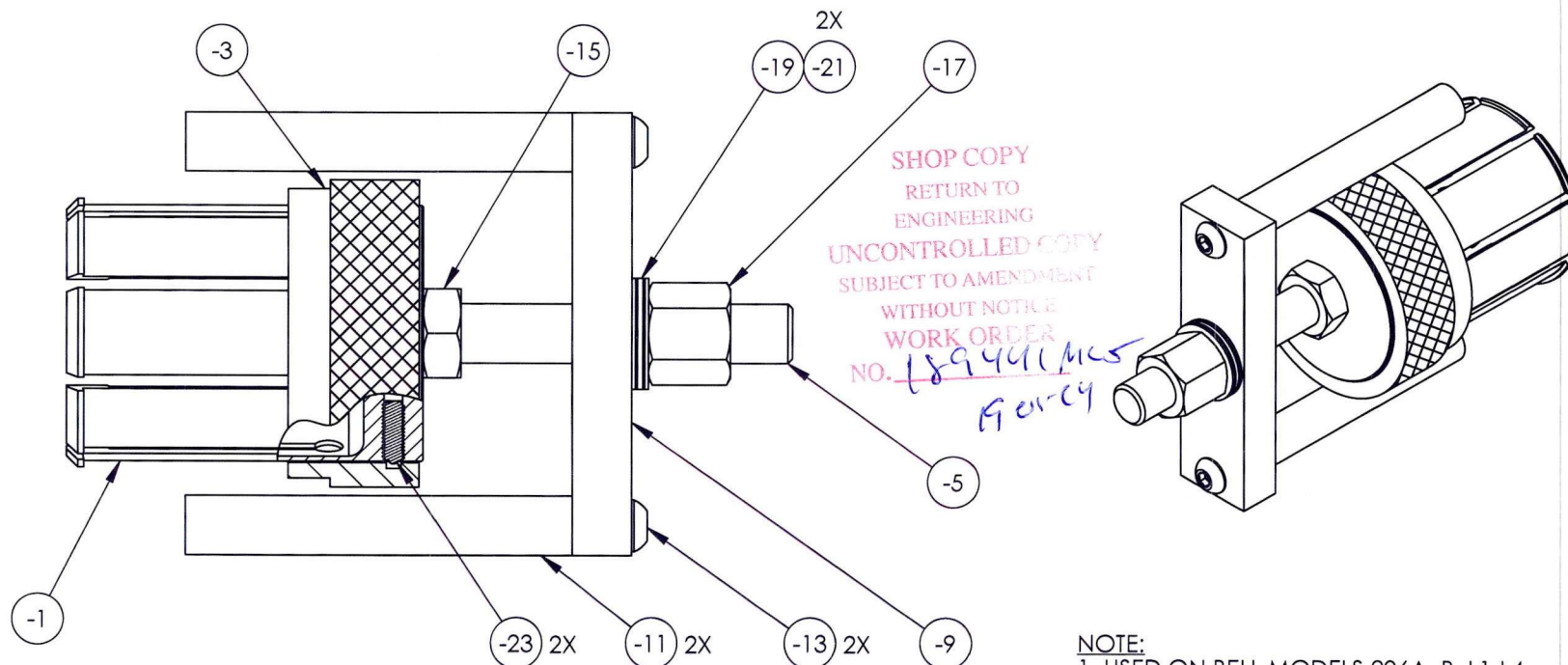
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	3408A94	20	27	0
	90565A330	10	56	0
	91255A542	20	78	0
	94846A525	10	90	0
	NTA-815	10	22	0
	RBT18560-1	10	3	0
	RBT18560-11	20	7	0
	RBT18560-3	10	11	0
	RBT18560-5	10	3	0
	RBT18560-9	10	3	0
	TRA-815	20	42	0
Part Specifications				
Specifications could not be found.				

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TEO ATTACHED

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 PULLER SLOT HOLES INCREASED TO Ø1/4 & WALL THINNED FOR FLEXABILITY, -3 RING SHORTENED & GROVE MOVED TO ALLOW -1 PULLER TEETH TO FULLY EXPAND, -7 ILLUMINATED, -9 CROSS BAR WIDTH INCREASED TO 1 FOR ADDED STRENGTH.	2/12/2003		
2		ADDED NEW BOM, TITLE BLOCK, & REV. TABLE, RE-ORGANIZED DWG.'S AND CORRECTED ERRORS. CREATED AN ASSEMBLY DWG, AND COMBINED TWO FILES.	11/20/2007	WP	RW
3		CH'D -9 HOLE FROM Ø.250 (X2) TO Ø.257 (X2) SER S.E.	12/29/2011	RJC	SE
4	15-0472	-9 CH'D ENGRAVE NOTE TO T/N, S/N, "MADE IN USA". UPDATED TO NEW DRAFTING STANDARDS.	1/5/2016	SM	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PULLER	H13		2
			-3	1	RING	DOM		3
		B/O	-5	1	SCREW	STEEL	1/2-20 UNF X 4 IN THREADED ROD (MCMASTER-CARR # 98750A483) MODIFIED	4
			-9	1	CROSS BAR	1018/1020 CR		5
			-11	2	UPRIGHT	1018/1020 CR		6
		B/O	-13	2	BTN-HEAD SKT CAP SCR	STEEL	1/4-20 UNC X 1 (MCMASTER-CARR # 91255A542)	1
		B/O	-15	1	JAM NUT	STEEL	1/2-20 JAM NUT (MCMASTER-CARR # 94846A525)	1
		B/O	-17	1	TALL NUT	STEEL	1/2-20 UNF (MCMASTER-CARR # 90565A330)	1
		B/O	-19	1	THRUST BEARING	STEEL	APPLIED # NTA-815	1
		B/O	-21	2	BEARING WASHER	STEEL	APPLIED # TRA-815	1
		B/O	-23	2	BALL PLUNGER	S.S.	10-32 X 33/64 (MCMASTER-CARR # 3408A94)	1

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560	REV 4
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
HEAT TREAT Q&T	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
FINISH AS PLATED	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SPEC AS PLATED	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: COLE	USED ON MODEL
CHECKED: DUERFELDT	SEE NOTE 1
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 2:3	DATE 5/2/2002
SHEET 1 OF 6	

DART
AEROSPACE

Container No: S151712

Part: RBT18560

Job No: 189441

Serial No/Batch: S151712

Revision: 4

Inspector:

Exp Date:

Instructions:

Dart AeroSpace
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Date: 02/07/19